

# Work Order ID 55388

January 15, 2010 9:07:24 AM



Page 1

Item ID: D4048-1

Accept

Revision ID:

Item Name: Mounting Lug

Start Date: 1/15/10 Start Qty: 4.00



Required Date: 1/22/10 Read Qty: 4.00



Reference:

10.01.15

Approvals: Process Plan:

Date:

Tooling:

Date:

Setup Start



Stop



QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4048

PA1

10/01/22

100



Bandsaw

Jeaspa Bandsaw

Memo

CUT BLANK 4.30" LONG

110



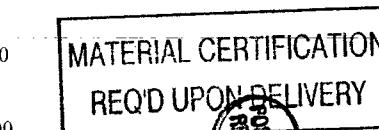
HAAS 1

HAAS CNC vertical machine #1

Memo

MILL AS PER DWG AND FOLIO FA893  
DWG REV: PA1  
FOLIO REV: PA

DEBURR



10/01/18

0.00

0.00

H.A 10/01/18

2

0

2

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 55388**

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January 15, 2010 9:07:24 AM

Item ID: D4048-1

Accept



Setup Start



Revision ID:

Item Name: Mounting Lug

Stop



Start Date: 1/15/10 Start Qty: 4.00



Cust Item ID:

Required Date: 1/22/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120



QC

QC2- Inspect parts off machine FAI/FAIB

0.00

B-A 10/01/18

2

Ø

Quality Control

130



QC

QC8- Inspect parts - second check

0.00

⇒ S1010120

(X2)

Quality Control

140



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

⇒ 91 10/01/21

(X2) 0

Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 55388**

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Item ID: D4048-1

Accept



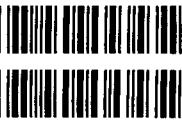
Setup Start



Revision ID:

Item Name: Mounting Lug

Stop



Start Date: 1/15/10 Start Qty: 4.00



Cust Item ID:

Required Date: 1/22/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

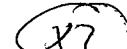
150



White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

10-01-21



Powdercoat

M113170

START : 3:30pm

=241

Memo

Temp : 320°F

0.00

Powder Coating

Fin : 4:00pm

160



QC3- Inspect Part Finish

0.00

BL 10-01-21



QC

Memo

0.00

Quality Control

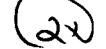
170



Identify as per dwg &amp; Stock Location: 468

0.00

10-1-22



Packaging

Memo

0.00

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 55388**

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January 15, 2010 9:07:25 AM

Item ID:	D4048-1		Accept		Setup	Start	
Revision ID:						Stop	
Item Name:	Mounting Lug					Stop	
Start Date:	1/15/10	Start Qty:	4.00		Cust Item ID:		
Required Date:	1/22/10	Req'd Qty:	4.00		Customer:		
Reference:							
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop		

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

POSITIVE RECALL  
 EFFECTIVE 10-01-30 AUTH MF  
 RELEASED 10-1-25 DATE 10-1-25

A Prototype test  
 10-01-30

# Picklist Print

January 15, 2010 9:07:23 AM

Page 1

Work Order ID: 55388



Parent Item: D4048-1



Parent Item Name: Mounting Lug

Start Date: 1/15/10

Required Date: 1/22/10

Comments: IPP REV:A NEW ISSUE JLM 10-01-07 VERIFIED BY:DD

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B30000X01.5 00		Purchased		No		100	f	16.8667	1.5074			

6061-T6 Bar 3.00 x 1.50



<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Main Warehouse		
MAT	16.8667	
109058	16.8667	<u>7243</u> ft M.A 10/01/10

magno 8740  
109058  
28/08/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 55388
Description: MOUNTING LUG		Part Number: D4048-1
Inspection Dwg:	Rev:	Page 1 of 1

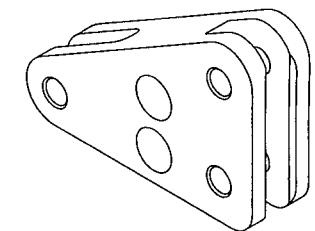
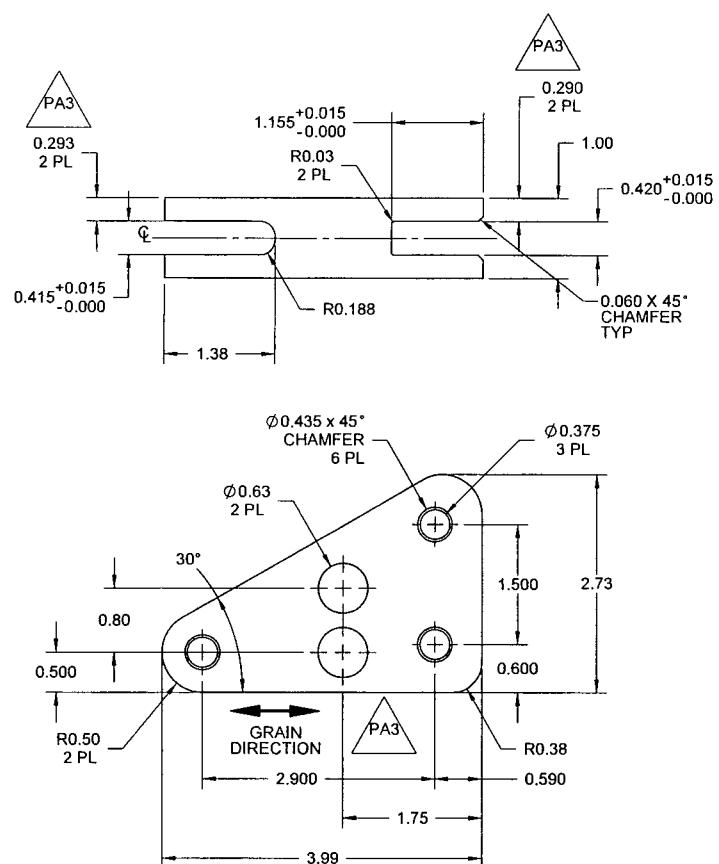
### FIRST ARTICLE INSPECTION CHECKLIST

First Article  Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.155	+.015 / -.000	1.160	✓			
0.415	+.015 / -.000	0.417	✓			
1.360	+/- .030	1.380	✓			
R 0.188	+/- .010	R 0.188	✓			
0.060x45°	+/- .010 x 1/2 °	0.061 x 45°	✓			
0.420	+.015 / -.000	0.420	✓			
1.00	+/- .030	1.001	✓			
R 0.50	+/- .030	R 0.500	✓			
0.500	+/- .010	0.499	✓			
0.80	+/- .030	0.800	✓			
30°	+/- 1/2 °	30°	✓			
Ø 0.63	+.008 / -.001	Ø 0.629	✓			
Ø 0.375	+.006 / -.001	Ø 0.381	✓			
2.73	+/- .030	2.730	✓			
1.500	+/- .010	1.499	✓			
0.600	+/- .010	0.600	✓			
R 0.38	+/- .030	R 0.380	✓			
0.590	+/- .010	0.590	✓			
1.75	+/- .030	1.748	✓			
3.99	+/- .030	3.992	✓			
2.900	+/- .030	2.900	✓			
1.740	+/- .030	1.744	✓			
2.900	+/- .010	2.906	✓			

Measured by:	B.A.	Audited by:	S	Prototype Approval:	
Date:	10/01/18	Date:	10/01/20	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



**D4048-1 MOUNTING LUG**

**NOTES:**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR PER AMS-QQ-A-225B (OR 4117/4128/4115/4116) PER AMS-QQ-A-200B (OR AMS 4160) REF DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.47 lbs

## PRELIMINARY ISSUE

10.01.18

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA3
MFG. APPR.		D4048	SHEET 2 OF 9
APPROVED		TITLE	SCALE
DE APPR.		<b>Mounting Lug Assy</b>	
DATE	10.01.18		

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